

Figure 1 consists of 12 bar charts, each representing a different demographic or attitudinal category. Each chart has six bars corresponding to the age groups: 18-24, 25-34, 35-44, 45-54, 55-64, and 65+. The y-axis for all charts represents the percentage of respondents, ranging from 0% to 100%.

- Category 1: Gender**

Age Group	Male (%)	Female (%)
18-24	50	50
25-34	50	50
35-44	50	50
45-54	50	50
55-64	50	50
65+	50	50
- Category 2: Education**

Age Group	High School (%)	Graduate (%)
18-24	10	90
25-34	15	85
35-44	20	80
45-54	25	75
55-64	30	70
65+	35	65
- Category 3: Income**

Age Group	Low (%)	Medium (%)	High (%)
18-24	40	40	20
25-34	35	45	20
35-44	30	50	20
45-54	25	55	20
55-64	20	60	20
65+	15	65	20
- Category 4: Marital Status**

Age Group	Single (%)	Married (%)	Divorced (%)	Widowed (%)
18-24	80	15	3	2
25-34	60	35	3	2
35-44	40	50	5	5
45-54	25	65	5	5
55-64	15	70	5	10
65+	10	75	5	10
- Category 5: Employment**

Age Group	Full-time (%)	Part-time (%)	Unemployed (%)
18-24	60	30	10
25-34	55	35	10
35-44	50	40	10
45-54	45	45	10
55-64	40	50	10
65+	35	55	10
- Category 6: Health**

Age Group	Good (%)	Fair (%)	Poor (%)
18-24	85	10	5
25-34	80	15	5
35-44	75	20	5
45-54	70	25	5
55-64	65	30	5
65+	60	35	5
- Category 7: Living Arrangements**

Age Group	Alone (%)	With Family (%)	With Friends (%)
18-24	10	80	10
25-34	15	75	10
35-44	20	70	10
45-54	25	65	10
55-64	30	60	10
65+	35	55	10
- Category 8: Transportation**

Age Group	Car (%)	Bike (%)	Public Transit (%)
18-24	70	10	20
25-34	65	15	20
35-44	60	20	20
45-54	55	25	20
55-64	50	30	20
65+	45	35	20
- Category 9: Communication**

Age Group	Phone (%)	Internet (%)	Email (%)
18-24	10	80	10
25-34	15	75	10
35-44	20	70	10
45-54	25	65	10
55-64	30	60	10
65+	35	55	10
- Category 10: Recreation**

Age Group	Sports (%)	Reading (%)	Travel (%)
18-24	60	20	20
25-34	55	25	20
35-44	50	30	20
45-54	45	35	20
55-64	40	40	20
65+	35	45	20
- Category 11: Volunteering**

Age Group	Yes (%)	No (%)
18-24	30	70
25-34	35	65
35-44	40	60
45-54	45	55
55-64	50	50
65+	55	45
- Category 12: Political Affiliation**

Age Group	Democrat (%)	Republican (%)	Independent (%)
18-24	60	30	10
25-34	55	35	10
35-44	50	40	10
45-54	45	45	10
55-64			

Figure 1 consists of 12 bar charts, each representing a different demographic or lifestyle category. Each chart has six bars corresponding to the age groups: 18-24, 25-34, 35-44, 45-54, 55-64, and 65+. The y-axis for all charts represents the percentage of respondents, ranging from 0% to 100%.

- 1. Gender:** Shows the percentage of Male and Female respondents. The percentage of females generally increases with age, while the percentage of males decreases.
- 2. Education:** Shows the percentage of respondents with a High School diploma versus a Graduate degree. The percentage of graduates increases significantly with age.
- 3. Income:** Shows the percentage of respondents in Low, Medium, and High income brackets. The percentage of high-income respondents increases with age.
- 4. Marital Status:** Shows the percentage of respondents who are Single, Married, Divorced, or Widowed. The percentage of married respondents is highest in the middle age groups.
- 5. Employment:** Shows the percentage of respondents who are Full-time, Part-time, or Unemployed. The percentage of full-time employment is highest in the middle age groups.
- 6. Health:** Shows the percentage of respondents in Good, Fair, or Poor health. The percentage of respondents in good health decreases with age.
- 7. Living Arrangements:** Shows the percentage of respondents living Alone, With Family, or With Friends. The percentage of respondents living alone increases with age.
- 8. Transportation:** Shows the percentage of respondents who use a Car, Bike, or Public Transit. The percentage of car use is highest in the middle age groups.
- 9. Communication:** Shows the percentage of respondents who use Phone, Internet, or Email. The percentage of internet and email use increases with age.
- 10. Recreation:** Shows the percentage of respondents who watch TV, watch Movies, or read. The percentage of TV watching is highest in the middle age groups.
- 11. Volunteering:** Shows the percentage of respondents who Volunteer or do not Volunteer. The percentage of volunteers increases with age.
- 12. Civic Participation:** Shows the percentage of respondents who Vote or attend Community Meetings. The percentage of voters increases with age.

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- Category 1: Gender**

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25-34	50	50
35-44	50	50
45-54	50	50
55-64	50	50
65+	50	50
- Category 2: Education**

Age Group	High School (%)	Graduate (%)
18-24	10	90
25-34	15	85
35-44	20	80
45-54	25	75
55-64	30	70
65+	35	65
- Category 3: Income**

Age Group	Low (%)	Medium (%)	High (%)
18-24	40	40	20
25-34	35	45	20
35-44	30	50	20
45-54	25	55	20
55-64	20	60	20
65+	15	65	20
- Category 4: Marital Status**

Age Group	Single (%)	Married (%)	Divorced (%)	Widowed (%)
18-24	80	15	3	2
25-34	60	35	3	2
35-44	40	50	5	5
45-54	25	65	5	5
55-64	15	70	5	10
65+	10	75	5	10
- Category 5: Employment**

Age Group	Full-time (%)	Part-time (%)	Unemployed (%)
18-24	60	30	10
25-34	55	35	10
35-44	50	40	10
45-54	45	45	10
55-64	40	50	10
65+	35	55	10
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Age Group	Good (%)	Fair (%)	Poor (%)
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25-34	80	15	5
35-44	75	20	5
45-54	70	25	5
55-64	65	30	5
65+	60	35	5
- Category 7: Living Arrangements**

Age Group	Alone (%)	With Family (%)	With Friends (%)
18-24	10	80	10
25-34	15	75	10
35-44	20	70	10
45-54	25	65	10
55-64	30	60	10
65+	35	55	10
- Category 8: Transportation**

Age Group	Car (%)	Bike (%)	Public Transit (%)
18-24	70	10	20
25-34	65	15	20
35-44	60	20	20
45-54	55	25	20
55-64	50	30	20
65+	45	35	20
- Category 9: Communication**

Age Group	Phone (%)	Internet (%)	Email (%)
18-24	10	80	10
25-34	15	75	10
35-44	20	70	10
45-54	25	65	10
55-64	30	60	10
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25-34	55	25	20
35-44	50	30	20
45-54	45	35	20
55-64	40	40	20
65+	35	45	20
- Category 11: Volunteering**

Age Group	Yes (%)	No (%)
18-24	30	70
25-34	35	65
35-44	40	60
45-54	45	55
55-64	50	50
65+	55	45
- Category 12: Political Affiliation**

Age Group	Democrat (%)	Republican (%)	Independent (%)
18-24	60	30	10
25-34	55	35	10
35-44	50	40	10
45-54	45	45	10
55-64			

3. The improvement according to claim 2 wherein said marginal region is formed as a peripheral lip extending around the perimeter of said resilient element.

4. The improvement according to claim 2 wherein said central region has a first thickness and wherein said marginal region has a second thickness that is greater than the first thickness.

5. The improvement according to claim 2 wherein said central region is provided with a head structure.

6. The improvement according to claim 5 wherein said head structure is formed as an integral one-piece construction with said central region.

7. The improvement according to claim 6 wherein said head structure has a rounded contact surface oriented to contact said workpiece when said workpiece is moved from the disengaged position toward the intermediate position.

8. The improvement according to claim 6 wherein said head structure has a flat contact surface oriented to contact said workpiece when said workpiece is moved from the disengaged position toward the intermediate position.

9. The improvement according to claim 5 wherein said head structure is defined by a plug disposed on said central region.

10. The improvement according to claim 9 wherein said plug is formed of a second material different from said first material.

11. The improvement according to claim 10 where said second material is lubricious.

12. The improvement according to claim 9 including a stanchion ring disposed on said central region, said plug being supported by said stanchion.

13. The improvement according to claim 1 wherein said chuck element has a central axis extending longitudinally therethrough and a recess formed at one end thereof whereby an upstanding peripheral rim extends peripherally around the one end of said chuck element, said resilient member being disposed in the recess.

14. The improvement according to claim 13 wherein a groove is formed in said recess, said resilient element including a central panel region having a ridge structure projecting away from a first side thereof, said ridge structure operative to be matably received in said groove thereby to secure said resilient element in a fastened state to said chuck assembly.

15. The improvement according to claim 14 wherein said groove has a wall formed at a large acute angle relative to a transverse plane that is oriented perpendicularly to the central axis of said chuck assembly and wherein said ridge structure is formed at the large acute angle whereby said central panel region extends transversely of said chuck assembly when in the fastened state with said ridge structure and said groove being in snap-fitted engagement with one another.

16. A chuck assembly mountable to a machine adapted to perform a machining function on a workpiece wherein said machine includes a spindle adapted to releasably mount said chuck assembly and at least one forming roller operative to interact with said chuck assembly

thereby to form a work station operative to perform a machining function on said workpiece, said machine including a positioning mechanism operative to advance so as to move said workpiece from a disengaged position, through and intermediate position and into an engaged position in said forming station wherein the machining function can be performed thereon and to retract whereby said workpiece can be ejected from said forming station, said chuck assembly comprising:

(A) a chuck element releasably mountable to said machine, said chuck element having

(1) a rim provided with a forming surface cooperative with said forming roller to perform the machining function, and

(2) a recess bounded by said rim; and

(B) a resilient element mounted to said chuck element and disposed in the recess, said resilient element

(1) formed of a flexible compressible first material, and

(2) sized and adapted so that

(a) when said workpiece is in the intermediate position, a first portion of said resilient element engages said workpiece and is operative to apply a first force to the workpiece, and

(b) when said workpiece is the engaged position, a second portion of said resilient element different from said first portion is operative to apply a second force to the workpiece, and

(c) when said positioning mechanism retracts, said first and second portions of said resilient element exert first and second forces, respectively, on said workpiece thereby to eject said workpiece from the forming station.

17. A chuck assembly according to claim 16 wherein said first portion is defined by a central region of said resilient element and wherein said second portion is defined by a marginal region of said resilient element.

18. A chuck assembly according to claim 17 wherein said chuck element has an axial passageway extending therethrough, said central region extending transversely across the axial passageway with said marginal region being formed as a peripheral lip extending around the perimeter of said resilient element.

19. A chuck assembly according to claim 18 wherein said central region has a first thickness and wherein said marginal region has a second thickness that is greater than the first thickness.

20. A chuck assembly according to claim 19 wherein said chuck element has a groove formed in said recess proximately to said rim such that the groove is bounded by said rim and an inner groove wall, said resilient element including a ridge structure projecting away from a first side thereof, said ridge structure operative to be matably received in said groove thereby to secure said resilient element in a fastened state to said chuck element with said marginal region supported against said inner groove wall.

21. A chuck assembly according to claim 17 wherein said central region has at least one vent port formed therethrough.

22. A chuck assembly according to claim 17 wherein said central region is provided with a head structure.

23. A chuck assembly according to claim 22 wherein said head structure is formed as an integral one-piece construction with said central region.

24. A chuck assembly according to claim 22 wherein said head structure is defined by a plug disposed on said central region.

25. A chuck assembly according to claim 24 wherein said central region has a bore formed therethrough, said plug including an enlarged contact head and a shaft extending from said contact head, said shaft mounted through the bore thereby to secure said plug to said resilient element.

26. A chuck assembly according to claim 25 wherein said shaft is provided with at least one vane, and including a locking washer operative to engage said vane thereby to mount said plug to said resilient element.

27. A chuck assembly according to claim 25 wherein said central region has an annular stanchion surrounding the bore, said contact head being supported on said stanchion.

28. A chuck assembly according to claim 24 wherein said plug is formed of a second material different from said first material.

29. A chuck assembly according to claim 28 wherein said second material is nylon.

	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	2101	2102	2103	2104	2105	2106	2107	2108	2109	2110	2111	2112	2113	2114	2115	2116	2117	2118	2119	2120	2121	2122	2123	2124	2125	2126	2127	2128	2129	2130	2131	2132	2133	2134	2135	2136	2137	2138	2139	2140	2141	2142	2143	2144	2145	2146	2147	2148	2149	2150	2151	2152	2153	2154	2155	2156	2157	2158	2159	2160	2161	2162	2163	2164	2165	2166	2167	2168	2169	2170	2171	2172	2173	2174	2175	2176	2177	2178	2179	2180	2181	2182	2183	2184	2185	2186	2187	2188	2189	2190	2191	2192	2193	2194	2195	2196	2197	2198	2199	2200	2201	2202	2203	2204	2205	2206	2207	2208	2209	2210	2211	2212	2213	2214	2215	2216	2217	2218	2219	2220	2221	2222	2223	2224	2225	2226	2227	2228	2229	2230	2231	2232	2233	2234	2235	2236	2237	2238	2239	2240	2241	2242	2243	2244	2245	2246	2247	2248	2249	2250	2251	2252	2253	2254	2255	2256	2257	2258	2259	2260	2261	2262	2263	2264	2265	2266	2267	2268	2269	2270	2271	2272	2273	2274	2275	2276	2277	2278	2279	2280	2281	2282	2283	2284	2285	2286	2287	2288	2289	2290	2291	2292	2293	2294	2295	2296	2297	2298	2299	2300	2301	2302	2303	2304	2305	2306	2307	2308	2309	2310	2311	2312	2313	2314	2315	2316	2317	2318	2319	2320	2321	2322	2323	2324	2325	2326	2327	2328	2329	2330	2331	2332	2333	2334	2335	2336	2337	2338	2339	2340	2341	2342	2343	2344	2345	2346	2347	2348	2349	2350	2351	2352	2353	2354	2355	2356	2357	2358	2359	2360	2361	2362	2363	2364	2365	2366	2367	2368	2369	2370	2371	2372	2373	2374	2375	2376	2377	2378	2379	2380	2381	2382	2383	2384	2385	2386	2387	2388	2389	2390	2391	2392	2393	2394	2395	2396	2397	2398	2399	2400	2401	2402	2403	2404	2405	2406	2407	2408	2409	2410	2411	2412	2413	2414	2415	2416	2417	2418	2419	2420	2421	2422	2
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(B) a resilient element disposed in the recess of said chuck element, said resilient element including

(1) a central panel portion formed of a flexible, resilient material, said central panel portion

(a) extending across the axial opening and

(b) having a head structure disposed thereon,

and

(2) a margin portion formed of a compressible material supported against said seat,

such that, when said positioning mechanism advances said workpiece from the disengaged position to the intermediate position, said head structure contacts said lid and said central panel portion flexes with a first force, and

such that, when said positioning mechanism advances said workpiece from the intermediate position to the engaged position, said margin portion compresses with a second force, and

such that, when said positioning mechanism retracts, said resilient element exerts a restorative force on said lidded container thereby to reject said lidded container from the forming station.

32. A chuck assembly according to claim 31 wherein said central panel portion has at least one vent port formed therethrough communicating with the axial opening in said chuck element.

33. A chuck assembly according to claim 31 wherein said head structure is formed as an integral one-piece construction with said central panel portion.

34. A chuck assembly according to claim 31 wherein said central panel portion and said margin portion are formed as an integral one-piece construction out of a material that is both resiliently flexible and compressible.

35. A chuck assembly according to claim 31 wherein said head structure is defined by a plug disposed on said central region.

36. A chuck assembly according to claim 35 wherein said central region has a bore formed therethrough, said plug including an enlarged contact head and a shaft extending from said contact head, said shaft mounted through the bore thereby to secure said plug to said resilient element.

37. A chuck assembly according to claim 36 wherein said central region has an annular stanchion surrounding the bore, said contact head being supported on said stanchion.

38. A resilient element adapted to mount on a chuck assembly, comprising

(A) a central panel portion formed of a flexible, resilient material, said central panel portion;

(B) a margin portion extending around said central panel portion and formed of a compressible material; and

(C) a head structure disposed on said central panel portion.

39. A resilient element according to claim 38 wherein said margin portion is thicker than said central panel portion.

40. A resilient element according to claim 38 wherein said head structure is formed as an integral one-piece construction with said central panel portion.

41. A resilient element according to claim 38 wherein said central panel portion and said margin portion are formed as an integral one-piece construction out of a material that is both resiliently flexible and compressible.

42. A resilient element according to claim 38 wherein said head structure is defined by a plug disposed on said central region.

43. A resilient element according to claim 38 wherein said central region has an annular stanchion surrounding the bore, said plug being supported on said stanchion.

44. A method of ejecting a work piece from a machine that is adapted to perform a machining function thereon where said machine includes a chuck element having a seat adapted to receive said workpiece in an engaged position, at least one forming roller operative to interact with said chuck element thereby to define a forming station for performing the machining function and a positioning mechanism operative to advance so as to move said workpiece from a disengaged position, through an intermediate position and into an engaged position in said forming station and to retract whereby said workpiece can be ejected from said forming station, comprising the steps of:

(a) securing a resilient element in fixed relation relative to said chuck element in a manner such that a central portion of said resilient element will be contacted by and deflected by said workpiece when said

workpiece is moved into the intermediate position thereby to exert a first restorative force tending to eject said workpiece from said chuck element;

(b) advancing said positioning mechanism whereby said workpiece is moved from the intermediate position into the engaged position simultaneously compressing a margin portion of said resilient element thereby to exert a second restorative force tending to eject said workpiece from said chuck element;

(c) holding said workpiece in the engaged position against the restorative forces until the machining function is completed; and

(d) retracting said positioning mechanism after the machining function is completed whereby to allow said resilient element to rebound to eject said workpiece, said resilient element being constructed such that the first and second restorative forces applied thereby are sufficient to eject said workpiece from said forming station after the machining function is performed thereon.

45. The method according to claim 44 wherein said machine is a lid seamer and wherein the machining function is seaming an end closure onto a container body.